

Date: Thursday, 2/23/2006 10:23:46 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	BRACKET ASSEMBLY
Job Number	: 25919	Part Number	: D2804041
Estimate Number	: 11036	Drawing Number	: D2804 REV B
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 2/23/2006 S.O. No. : N/A	Drawing Revision	: B
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 3/22/2006 Qty: 10 Um: Each
Previous Run	: N/A		
Written By	<u>KJ/JLM</u>		
Checked & Approved By	<u>KJ 06.02.23</u>		
Comment	Est F 05.08.30 MS21043-3 was MS21042L3		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D28041	STA 155 Bracket	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) STA 155 Bracket	
		Pick: Qty Part Number Description Batch 1 D2804-1 Bracket	B14241 (1) B23622 (9)
2.0	D28051	Stop	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) Stop	
		Pick: Qty Part Number Description Batch 1 D2805-1 Stop	(10) B2593
3.0	D2809	Bushing	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) Bushing	
		Pick: Qty Part Number Description Batch 1 D2809 Bushing	(10) B25959
4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Press D2805-1 into arm as per Dwg D2804	5A1 06:05:08 (9) 5B 06/02/07 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06.03.15	1 2	-1 hardware for ASS'Y Press fit for an -041. ^{correct} change I.P.PAs shown. permanent change				<i>AB</i> <i>open</i>	<i>J</i> 06.03.15

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.05.08	4	1 bracket -1 scrap. : 02805-1 Scrap. Parts were press fitted together backwards Human error.		Scrap! repare . destroy parts.		<i>J</i> 06.05.08		<i>J</i> 06.05.08

NOTE: Date & initial all entries

Date: Thursday, 2/23/2006 10:23:47 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 25919

Part Number: D2804041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-05-09

⑨

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 05 09 (9)

(9)

8.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2809 into arm as per Dwg D2804

SAD 06:05:100

⑨

9.0 AN3C16A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch

2 AN3C16A Bolt

117944

10.0 MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

Pick:

Qty Part Number Description Batch

2 MS21043-3 Nut

m160 218

✓

11.0 NAS1515H3

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Washer

Pick:

Qty Part Number Description

Batch

4 NAS1515H3

Washer

⑩ B19633

A/R

LPS-3

Corrosion Spray

117045

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/23/2006 10:23:47 AM
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Drawing Name: BRACKET ASSEMBLY

Job Number: 25919

Part Number: D2804041

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804

2-Assemble as per Dwg D2804.

SAD 06:05:10 ⑦

13.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

14.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 158

SL 06/05/10 ⑦

15.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

1 06/05/15 ⑦

Job Completion



U 06-05-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/05/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

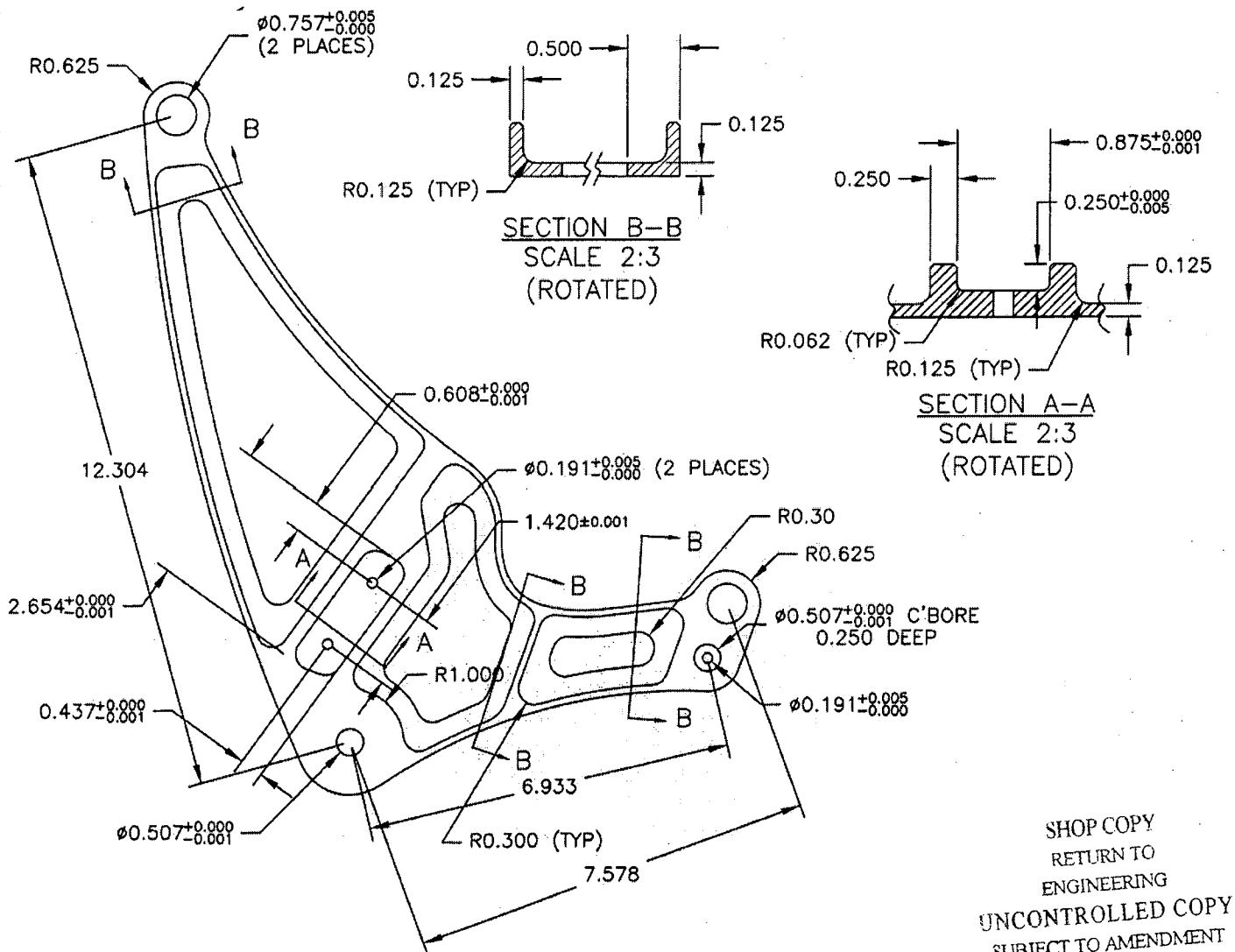
NOTE: Date & initial all entries

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2804
DATE 04.11.22	TITLE STA 155 BRACKET	REV. B SHEET 1 OF 2
		SCALE 1:3
A B	00.11.07 04.11.22	NEW ISSUE ADD CUTOUTS & -043/-044

RELEASED

05.03.11 *[Signature]*



D2804-1 BRACKET (SHOWN), D2804-2 BRACKET (OPPOSITE)

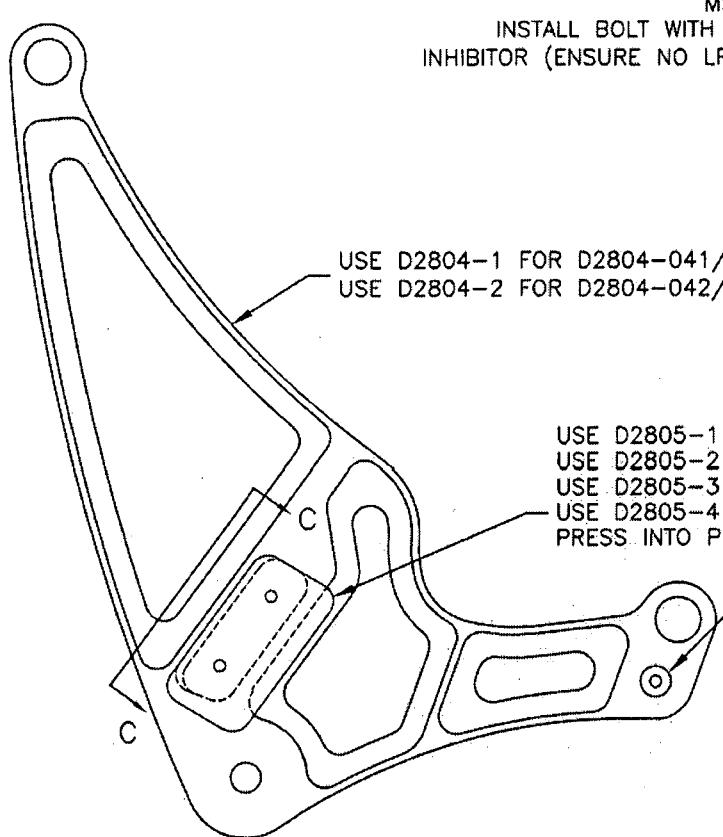
- 1) MACHINE PER DRAWING FILE "D2804.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 – 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2804	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 155 BRACKET	SCALE 1:3



SECTION C-C
SCALE 1:3
(ROTATED)

SHOP COPY
RETURN TO
ENGINEERING
RELEASED
UNCONTROLLED COPY
05-03-11 *[initials]* SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 25919

D2804-041/-043 BRACKET ASS'Y (SHOWN),
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

- 6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANTEX (4.3.5.6)
OR BLACK SANTEX (4.3.5.7) OR GREEN SANTEX (4.3.5.8) PER DART QSI 005 4.3